Work Order ID 74471

Monday, October 03, 2011 9:25:10 AM

Item ID: D2661-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 10/28/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** M.L.J **Date:** 11/10/03 **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2661	Rev D								
100	HAAS CNC VERTICAL MACHINING #1	0.00 BA 11/10/14				10	ϕ		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number.☐Fixturing Inspection last completed 11/10/13 by SRL ☐1-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐2-Machine Step No 2 of Folio and visually inspect as per attached Dimension								
110	CONVENTIONAL MILLING MACHINE	0.00 B.A 11/10/14				10	ϕ		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120	QC2- Inspect parts off machine FAI/FAIB	0.00 B.A 11/10/14				10	ϕ		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74471

Monday, October 03, 2011 9:25:10 AM

Item ID: D2661-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 10/28/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	JL 11-10-17			(10)			
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				10 X ∅ M 11/10/17			
HandFinish	**Memo**	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				10 X ∅ M 11/10/18			
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 9:00 ☐OVEN TEMPERATURE: 320°F ☐FINISH TIME: 9:30								

M11745

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE					

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74471

Monday, October 03, 2011 9:25:10 AM

Item ID: D2661-1 **Accept**

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 **Start Qty:** 10.00

Required Date: 10/28/2011 **Req'd Qty:** 10.00

Reference:

Cust Item ID:

Customer:

Setup Start **Stop**

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				10 count	d	11/10/18	
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location ST-476	0.00							
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

SP 11-10-18

11/10/18

MF 11-10-18

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 9:25:14 AM

Work Order ID: 74471

Parent Item: D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 **Required Date:** 10/28/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat - in house process□EC□
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	73.0000	1	10			
Saddle Billet, 7075													

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

3
7

ark 11/10/13

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74471
Description: 206 Saddle, Outboard, Left side	Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.111	0.110	0.110	0.111		
B	0.100	0.140		.111	.111	0.112	0.115		
C	~~1.250~~	~~1.270~~		1.134	1.132	1.133	1.139		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.253	0.253	0.252	0.249		
F	~~1.437~~	~~1.467~~		1.321	1.320	1.321	1.322		
G	0.210	0.230		0.222	0.222	0.222	0.223		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.5715	1.5725	1.578		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.111	0.111	0.111	0.111		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		.317	.317	0.317	0.317		
T	2.495	2.505		2.500	2.506	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.367		
V	0.787	0.807		0.798	0.798	0.798	0.798		
W	0.540	0.560		0.550	0.552	0.552	0.552		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	0.258	0.258		
Z	0.912	0.932		0.920	0.920	0.920	0.920		
AA	0.490	0.510		0.501	0.500	0.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

1.125-1.145

1.313-1.343

Measured by:		/
Date:	11/10/13	11/10/14

Audited by	
Date:	11-10-17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74471

DART AEROSPACE LTD	Work Order:	~~74493~~
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-~~1~~
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		Date
A	0.100	0.140		0.111	.112	.112	.112		
B	0.100	0.140		0.114	.112	.112	.112		
C	~~1.250~~	~~1.270~~		1.1377	1.134	1.135	1.135		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.251	.251	.252	.250		
F	~~1.437~~	~~1.467~~		1.327	1.320	1.320	1.320		
G	0.210	0.230		0.227	.222	.222	.222		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.572	1.574	1.574		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.111	0.111	0.111	0.111		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.517	0.517	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.798	.794	.795	.795		
W	0.540	0.560		0.552	.550	.549	.547		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.920	.919	.919	.922		
AA	0.490	0.510		.501	.500	.500	.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

7.
11.10.05
25-1.145
1.313-1.343

Measured by:	DA / [signature]
Date:	11/10/14 / 11/10/14

Audited by	JL
Date:	11-10-17

Rev	Date	Change	Revised by	Approved
A	-	New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	74471 ~~74358~~
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-~~1~~
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions 9	10				Date
A	0.100	0.140		.112	.110				
B	0.100	0.140		.114	.111				
C	~~1.250~~	~~1.270~~		1.138	1.134				
D	0.615	0.685		.675	.675				
E	0.240	0.260		.250	.250				
F	~~1.437~~	~~1.467~~		1.321	1.319				
G	0.210	0.230		.223	.220				
H	0.100	0.180		.135	.135				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.578	1.573				
K	0.235	0.240		.238	0.238				
L	0.100	0.120		.114	0.115				
M	0.990	1.010		1.000	0.999				
N	0.510	0.515		.572	0.512				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.315	0.315				
S	0.315	0.322		.317	.317				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.795	.797				
W	0.540	0.560		.549	.549				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.920	.919				
AA	0.490	0.510		.498	0.500				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	[signature] / HA
Date:	11/10/17 / 11/10/17

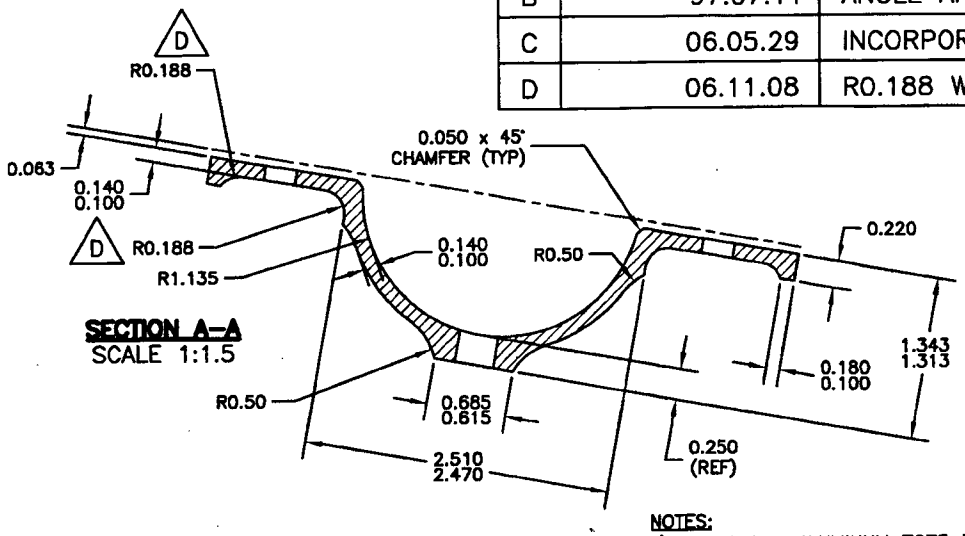
Audited by	JL
Date:	11-10-17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
	CB		
CHECKED	APPROVED	DRAWING NO.	REV. D
PH		D2661	SHEET 1 OF 1
DATE		TITLE	SCALE
06.11.08		SADDLE OUTSIDE	1:3

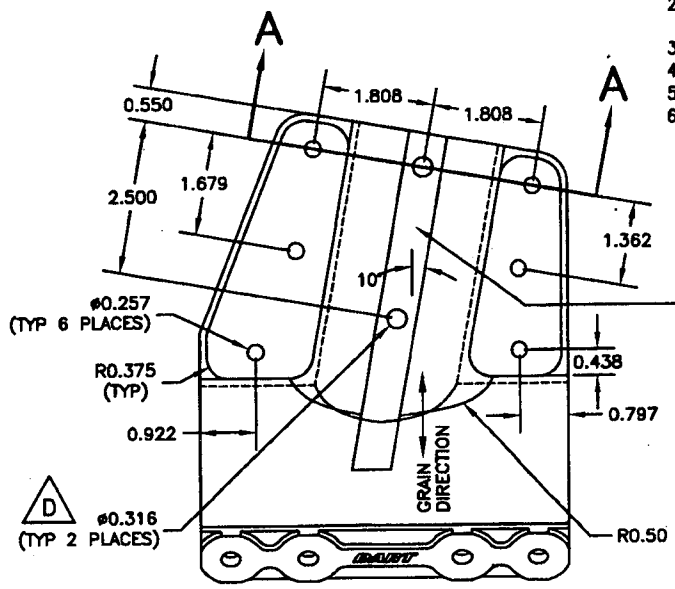
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; ø0.316 WAS ø0.313



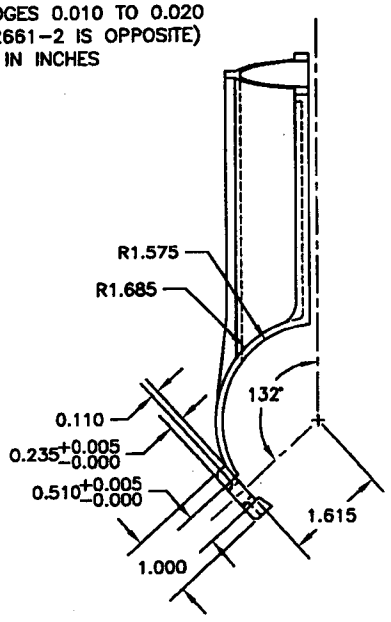
SECTION A-A
SCALE 1:1.5

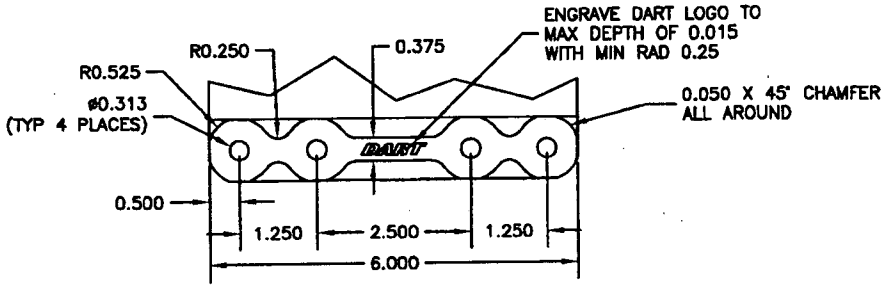
RELEASED
07-02-12
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74471 M.L.J
11/10/03

NOTES:
1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010





D2661-1 SADDLE OUTSIDE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries